

Wednesday, 3/26/2008 9:52:49 AM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR DOUBLER
Job Number	: 38164		
Estimate Number	: 12681		
P.O. Number	:	Part Number	: D3594043
This Issue	: 3/26/2008 S.O. No. :	Drawing Number	: D3594 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 33875	Material	:
Written By	:	Due Date	: 4/4/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JD 08.3.27</u>		
Comment	: Est Rev :A New Issue 07-01-22 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s)

6061-T6 .080 Sheet

Batch: 107276 x 7 = 3.8 B 8-3-28

1295 X 3 = 1.7

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: A

Prog Rev: A

HB 8-3-28

2-Deburr if necessary

HB 8-3-28

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-3-28

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 20/03/28 CE

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

mrf

08-03-31

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:52:49 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 38164

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/31 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-01

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 08/04/01 (10)

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Anchor nuts

BATCH: 105805

P

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit - Total : 20.0000 Each(s)

Rivet

BATCH: M1021

P 8/4/01 (10)

11.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

ml 08/04/03

X10

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/03 (X10) 043

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 240

AS 08/04/03

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:52:49 AM  
User: Kim, Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 38164

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/04 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mf* 08-04-03

*W*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

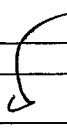
NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38164
<b>Description:</b> Floor Doubler, LH		<b>Part Number:</b> D3594-3
<b>Inspection Dwg:</b> D3594 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.24	+/-0.030	12.24	✓			
7.85	+/-0.030	7.85	✓			
7.313	+/-0.010	7.313	✓			
2.688	+/-0.010	2.688	✓			
Ø0.323	+0.006/-0.001	.324	✓			
Ø0.129	+0.005/-0.001	.129	✓			
0.359	+/-0.010	.359	✓			
0.718	+/-0.010	.719	✓			
0.81	+/-0.030	.823	✓			
2.35	+/-0.030	2.32	✓			

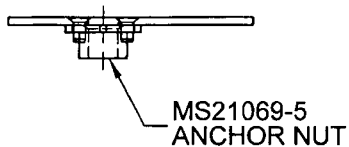
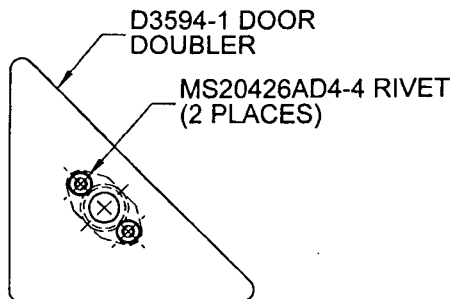
<b>Measured by:</b> HB	<b>Audited by:</b> 	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-3-28	<b>Date:</b>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue      P/O D3594-043	KJ/JLM 	

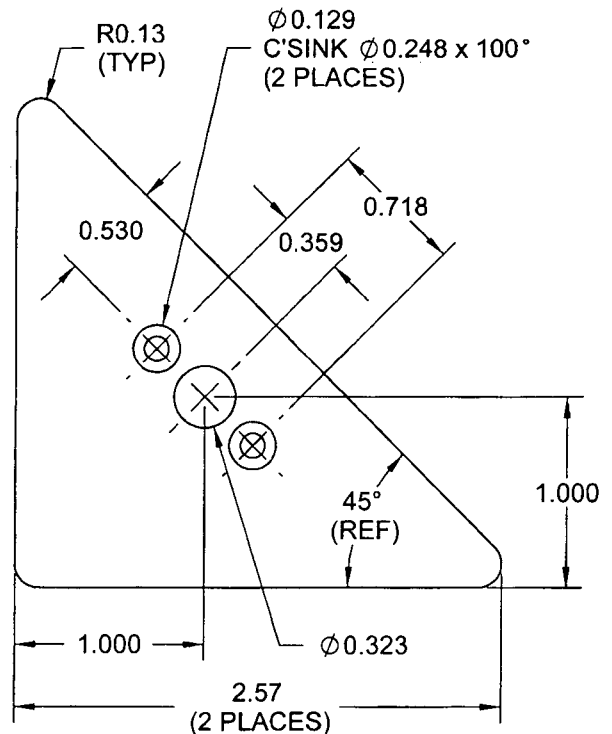
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 WITHOUT NOTICE  
 WORK ORDER  
 NO. \_\_\_\_\_

**DART****RELEASED**  
07.07.11  
Per [signature]

DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [signature]	APPROVED [signature]	DRAWING NO. <b>D3594</b>	REV. A SHEET 1 OF 3
DATE <b>07.04.13</b>	TITLE <b>DOUBLER</b>		SCALE 1:1
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**D3594-041 DOOR DOUBLER ASSEMBLY**   
SCALE 1 : 2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET

**D3594-1 DOOR DOUBLER**

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WORK ORDER  
NO. 38164

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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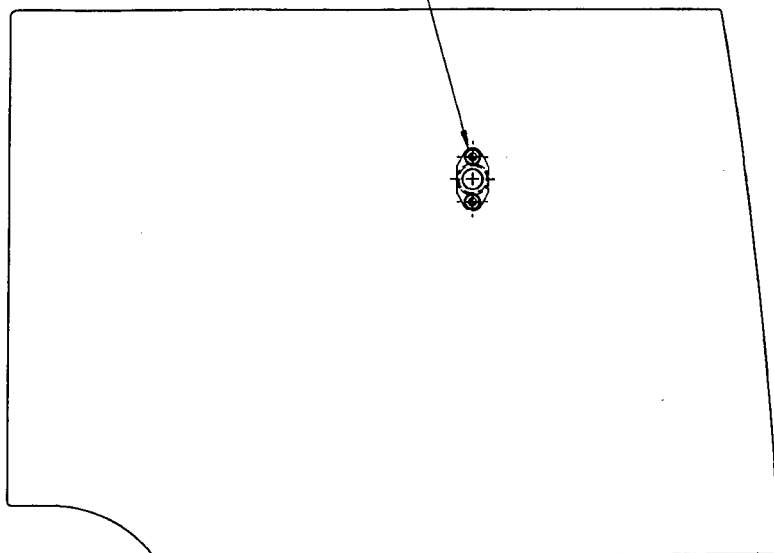


DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3594</b>	REV. A SHEET 2 OF 3
DATE <b>07.04.13</b>		TITLE <b>FLOOR DOUBLER ASSEMBLY</b> SCALE 1:3	

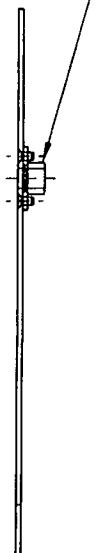
**RELEASED**  
07.07.11 *H*

Per SW #1001

MS20426AD4-4 RIVET  
(2 PLACES)



MS21069-5  
ANCHOR NUT



D3594-3 FLOOR DOUBLER (D3594-043)  
D3594-4 FLOOR DOUBLER (D3594-044)

**D3594-043 FLOOR DOUBLER ASSEMBLY**  
**(D3594-044 OPPOSITE)**

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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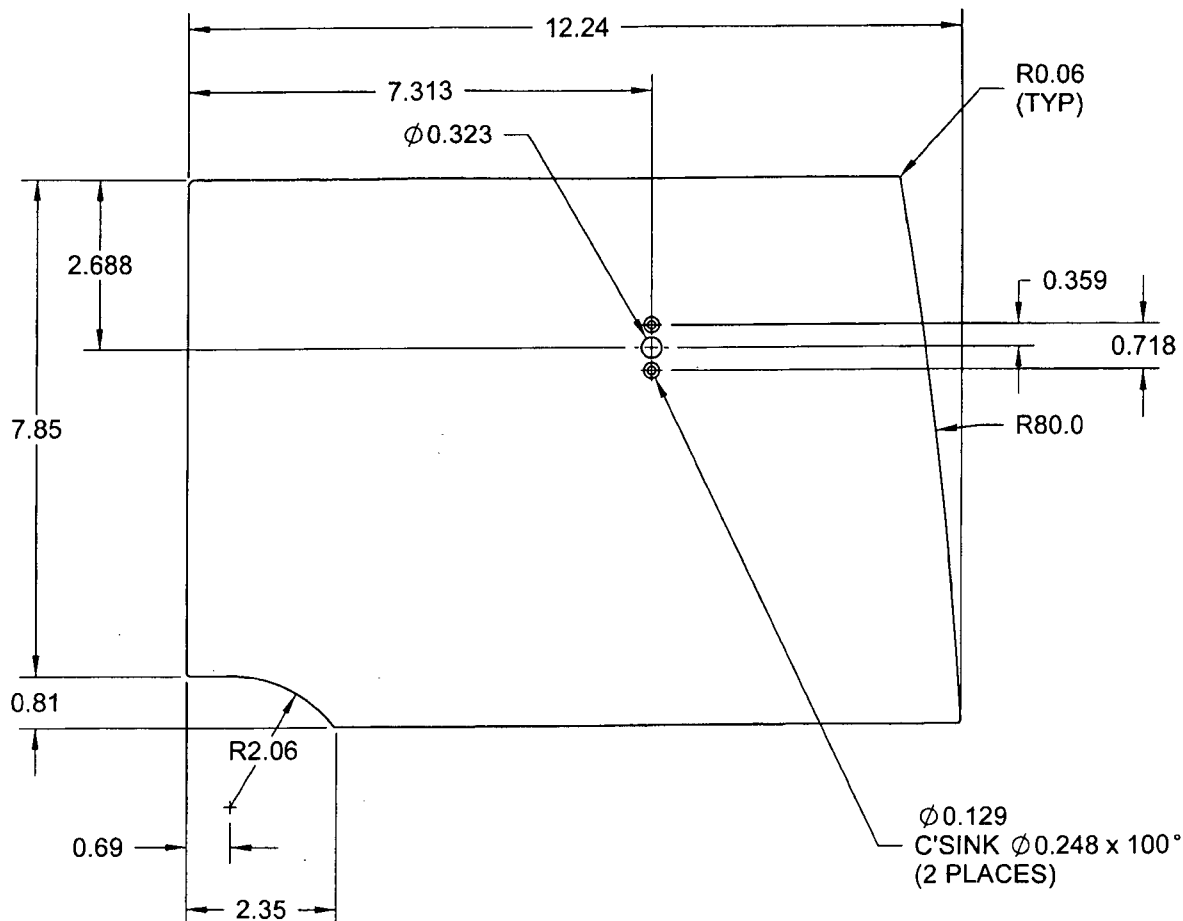


DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3594	REV. A SHEET 3 OF 3
DATE 07.04.13		TITLE DOUBLER	SCALE 1:3

RELEASED

07.07.11 13

PER 60541001



**D3594-3 FLOOR DOUBLER**  
**(D3594-4 OPPOSITE)**

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